

Work Order ID 132104

Friday, April 24, 2015 3:25:51 PM

132104

Page 1

Item ID: 647.2201 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cross Assembly
 Start Date: 4/24/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference: NCR15-4826

Approvals: Process Plan: WUF Date: 15-4-24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.2200	N/C

200 0.00
200
 QC Memo 0.00
 Quality Control PULL FROM STOCK 647.2201 X 4 B92117
 REWORK PER NCR15-4826
4 FF MAY 11 2015

210 0.00
210
 Small Fab Memo 0.00
 Small Fab REMOVE HELICOIL AND INSTALL NEW ONE AS PER DRAWING
* MS21209 P1-10 M131139 x FF MAY 11 2015
4 FF MAY 11 2015

220 0.00
220
 QC Memo 0.00
 Quality Control QC5- Inspect part completeness to step on W/O
4 MAY 14 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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Friday, April 24, 2015 3:25:51 PM

Item ID: 647.2201

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cross Assembly

Stop *NS2*

Start Date: 4/24/2015 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 5/7/2015 **Req'd Qty:** 4.00

4

Customer:

Reference: NCR15-4826

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

230

Identify as per dwg & Stock Location: CAC 4 0.00

0.00

230

Packaging

Memo

0.00

Packaging

4

DATE
27
9-9

MAY 19 2015

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

ALJ

MAY 19 2015

ML-

MAY 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Friday, April 24, 2015 3:25:50 PM

Page 1

Work Order ID: 132104

132104

Parent Item: 647.2201

647 2201

Parent Item Name: Cross Assembly

Start Date: 4/24/2015

Required Date: 5/7/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD
B Now machined in house JFS 15/03/02 Verified by:JLM

IPP Rev:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.2201		Manufactured	No				Each	5.0000		4			

647 2201

Cross Assembly

Location

Loc Qty

Loc Code

cck079

5

94797

5

4 x 100 92117 mf

24 FF

MAY 11 2015

15-4-24

* MS 21209 F 1-10

m 131139

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																								
		OTHER : _____																							

Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Friday, April 24, 2015

Details			
Raised Date 4/24/2015	Status Open	Owner Forbes, Nigel	Number NCR15-4826
Target Date 5/15/2015	Standard		Severity
Process Employee finding		Audit	
Raised By Person Downing, Eric M		Raised Against (Department or Supplier)	Fault Category Apical drawing
Details found when comparing manufactured 647.2201 here at Dart hawkesbury to the originals sent here from apical that the he li-coils were installed incorrectly.			
Keywords		Product 647.2201	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 5/14/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Poulin, Mario	5/8/2015	
create work order to pull all apical parts 647.2201 from stock & remove heli-coil and install new one as per drawing			

Verification & Review			
Target Date 5/14/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02678

SHEET 1 OF 1

DWG NO. 647.2200

REV: N/C

PREPARED
BY

R. ROSANO

DATE: 09/01/10

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CROSS ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: ADDED DELTA NOTE 6, LOCATE SPECIFIC HOLES FOR HELICAL INSERT

SHEET 1, A1 IS:

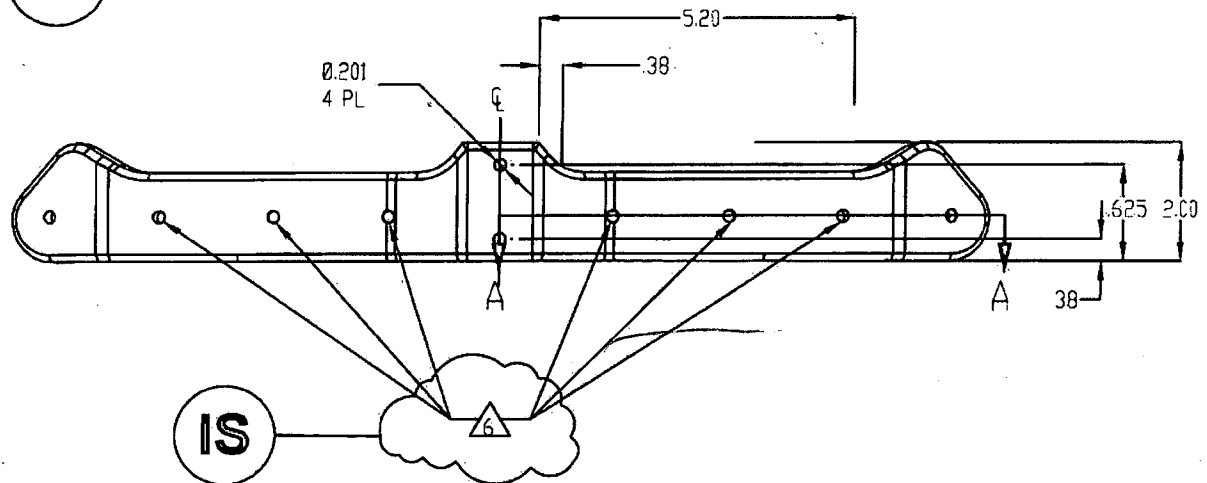
NOTES:

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, CARDINAL 4860-50 PRETREATMENT PRIMER, PRIME IAW MIL-P-23377J TYPE I CLASS N
3. PART DIMENSIONS CONTROLLED BY CAD MODEL
F/N 1 FILE NAME: 647.2210 REV PRT CROSS LAST MODIFIED 06/09/09
4. DEBURR AND BREAK ALL SHARP EDGES
5. IDENTIFY IAW MFR 120

△ INSTALL F/N 2, HELICAL INSERTS, AFTER ANODIZING. TAP FOR #10-32
HELICAL INSERT = 1.0 DIA. 6 PL.

IS

SHEET 3, B4 IS:



2	R	601.0987		6	HELICAL INSERT	MS21209F110	△ 6
F/N	TC	PART NUMBER		2201	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED	
					☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	☐ MAJOR ☒ MINOR	☐ YES ☒ NO

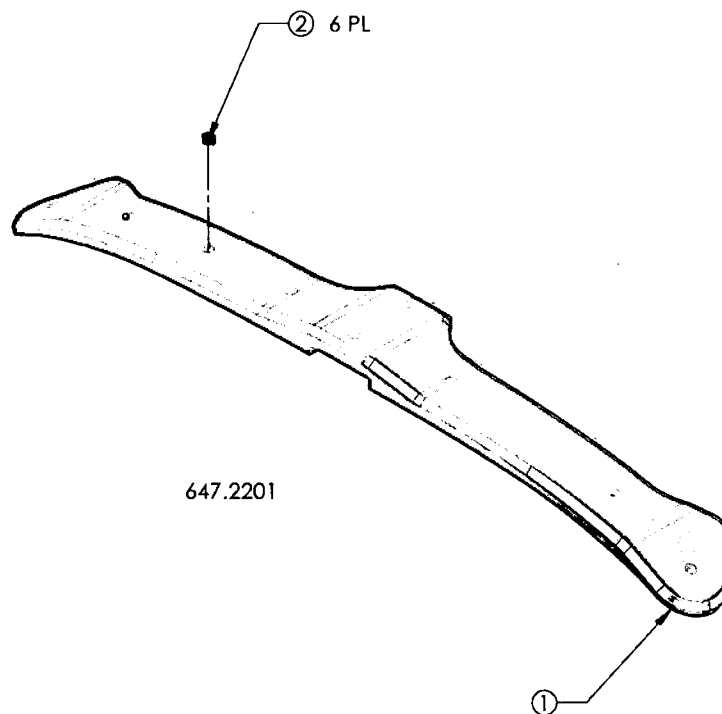
1 2 3 4 5 6 7 8

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: PR1		N/C
N/C	INITIAL RELEASE	06/09/09	P. BRAVO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 PART DIMENSIONS CONTROLLED BY CAD MODEL
F/N 1 FILE NAME: 647.2210 REV PR1 CROSS LAST MODIFIED 06/09/09
4. DEBURR AND BREAK ALL SHARP EDGES
5. IDENTIFY IAW MPP-120

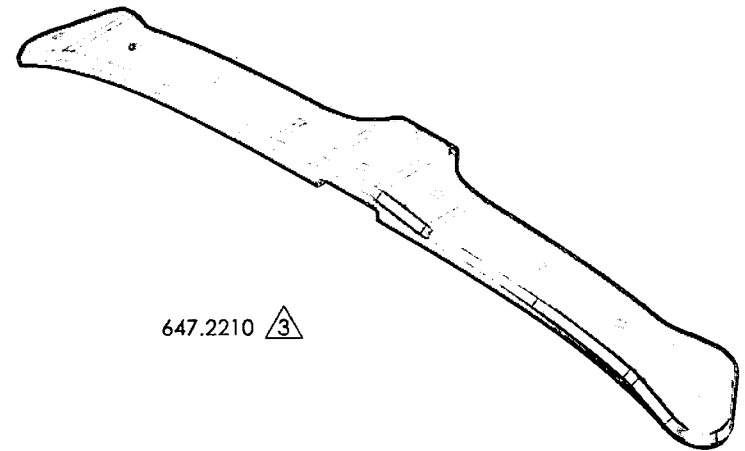


UNINCORPORATED ECN(s)

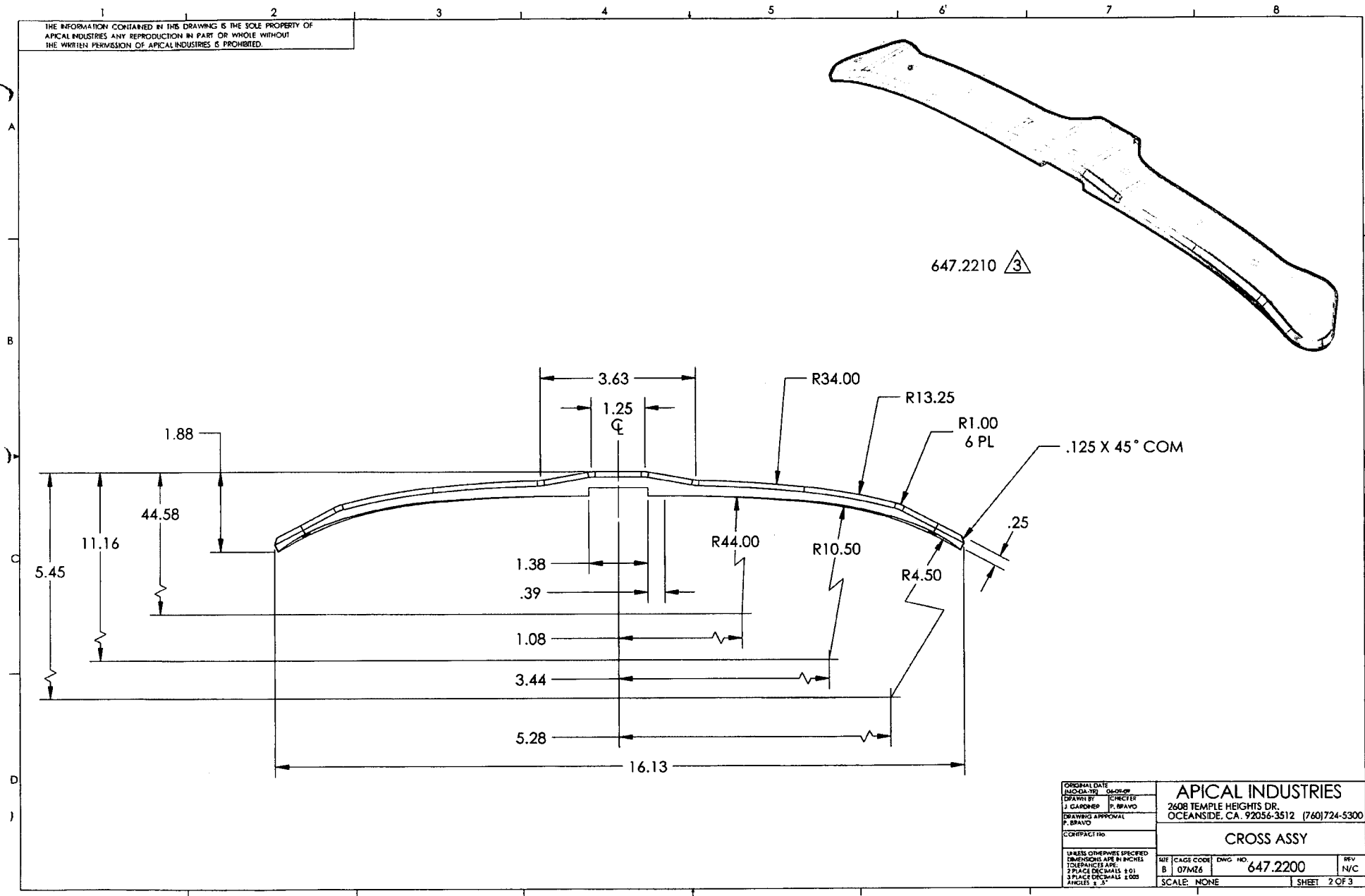
02478

	6	2	601.0987	HELICAL INSERT	MS21209F110	
	1	1	647.2210	CROSS		
			647.2201	CROSS ASSY		
	2201	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST			
NEXT ASSY (S)			APICAL INDUSTRIES			
647.1300			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300			
			CROSS ASSY			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
SIZE	CAGE CODE	DMG. NO.	REV	REV		
B	07M16	647.2200	N/C	N/C		
SCALE: NONE			SHEET 1 OF 3			

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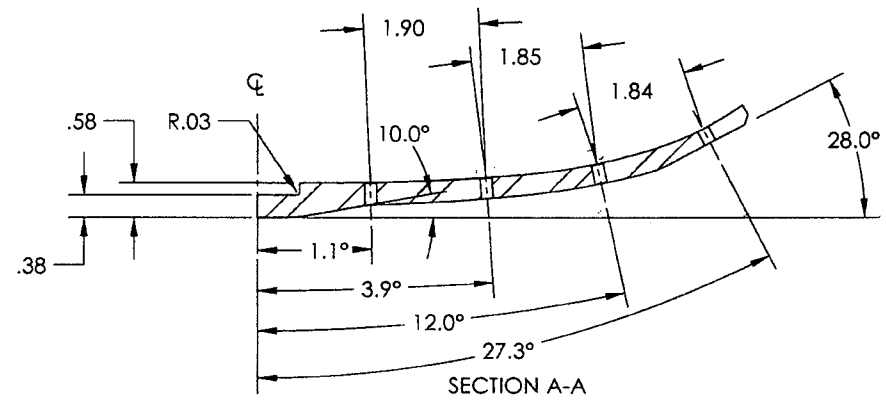
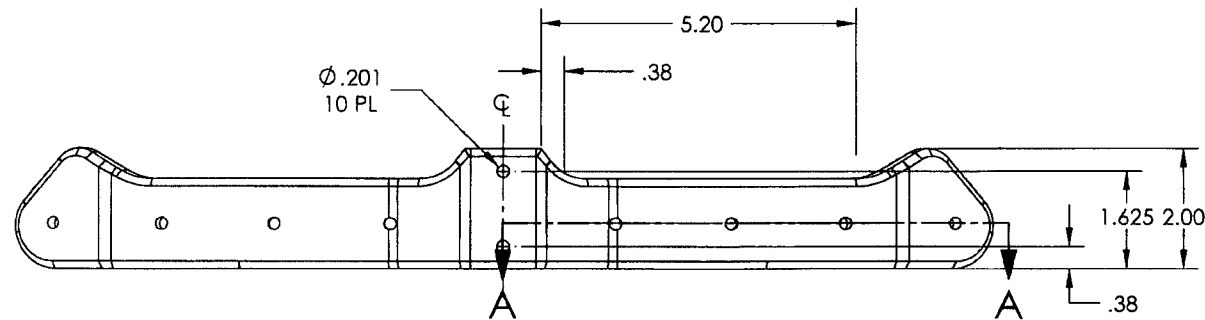


647.2210 $\triangle 3$



ORIGINAL DATE 10-03-97		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAVO		OCEANSIDE, CA 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		CROSS ASSY	
C/CORRECTION		REV	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV B 07/MZG	N/C
SCALE: NONE		SHEET 2 OF 3	

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ORIGINAL DATE (M/D/YR) 01-09-09		APICAL INDUSTRIES	
DRAWN BY J. CANNON		2608 TEMPLE HEIGHTS DR.	
CHECKED P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL:		CROSS ASSY	
P. BRAVO			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SHEET B	REV. N/C
CAGE CODE 07MZ6		DWG. NO. 647.2200	
SCALE: NONE		SHEET 3 OF 3	